

Work Order ID 91845

October-19-12 12:45:08 PM

91845

~~DWG~~ **U/R**

Page 1

Item ID: D3256-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 10/18/12 Start Qty: 6.00

6

Cust Item ID:

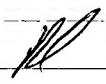
Required Date: 11/02/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: 

Date: 12-10-12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3256	D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3256								
384-032	Dwg Rev: <u>D</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

6 1312-10-21

6 1312-10-21

Smb
12/10/22

6

91845

October-19-12 12:45:08 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/18/12 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 11/02/12 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

130

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form using D3256-1T2

140

QC5- Inspect part completeness to step on W/O

0,00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 27176 0.00

0.00

150

Packaging

Memo

0.00

Packaging

Work Order ID 91845***91845***

Page 3

October-19-12 12:45:08 PM

Item ID: D3256-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 10/18/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/02/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/11/22 *[Signature]*
MF
12-11-21

Picklist Print

October-19-12 12:45:08 PM

Page 1

Work Order ID: 91845

Parent Item: D3256-1

Parent Item Name: Panel

Start Date: 10/18/12

Required Date: 11/02/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	219.1800	0.987	6.2336844			
304/316 .032 Sheet													

Location

Loc Qty

Loc Code

MAT020

219.18

118271

8.88

120866

32.8

121889

152.75

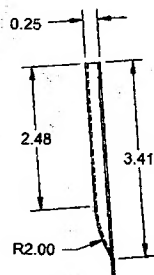
122736

24.75

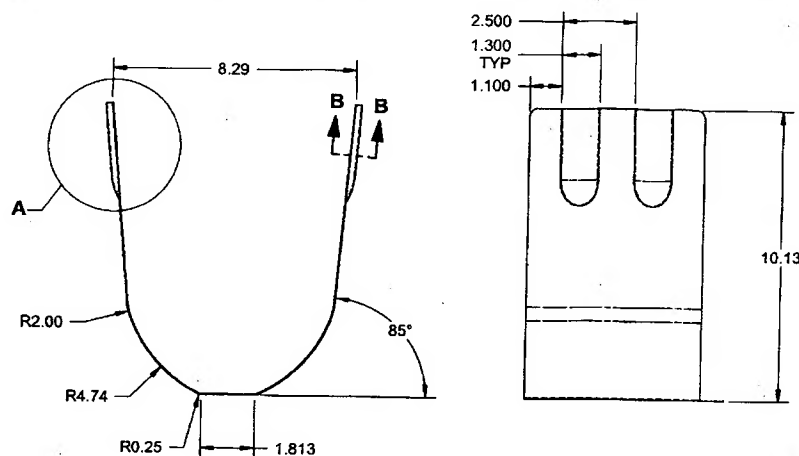
121889

1812-10-21

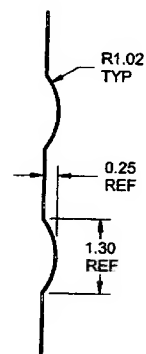
(6)



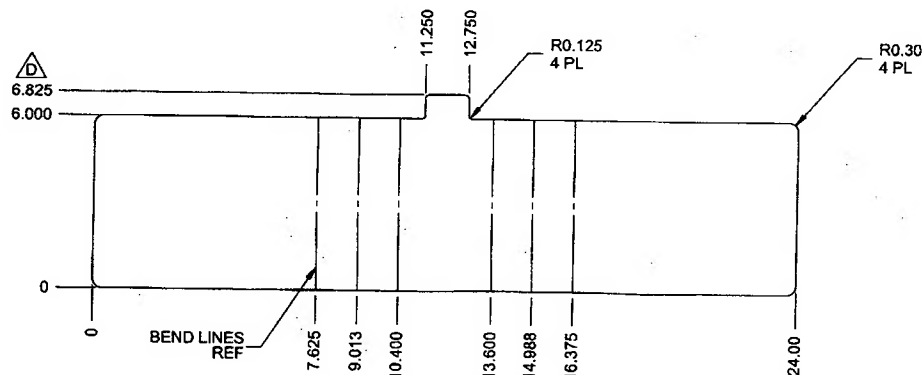
DETAIL A
SCALE 2X



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



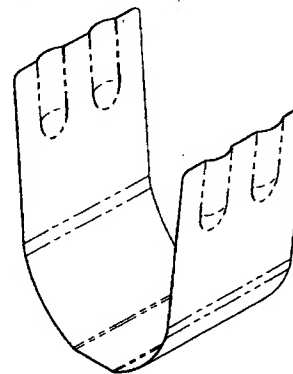
SECTION B-B
SCALE 2X
(VIEW ROTATED)



D3256-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK
PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N "BXXXX" PER DART QSI 044 6.1 (FINE-POINT PAINT MARKER)
- 7) WEIGHT: 1.37 lbs



RELEASE
2011-11-10
UNDER REVIEW

12.10.10
FOR CHANGE - 10K!

D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.83 WAS 0.45 (ZN C8-2); REASON: PAR11-124.	MB	11.10.25
C	D3256-041 ELIMINATED; REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

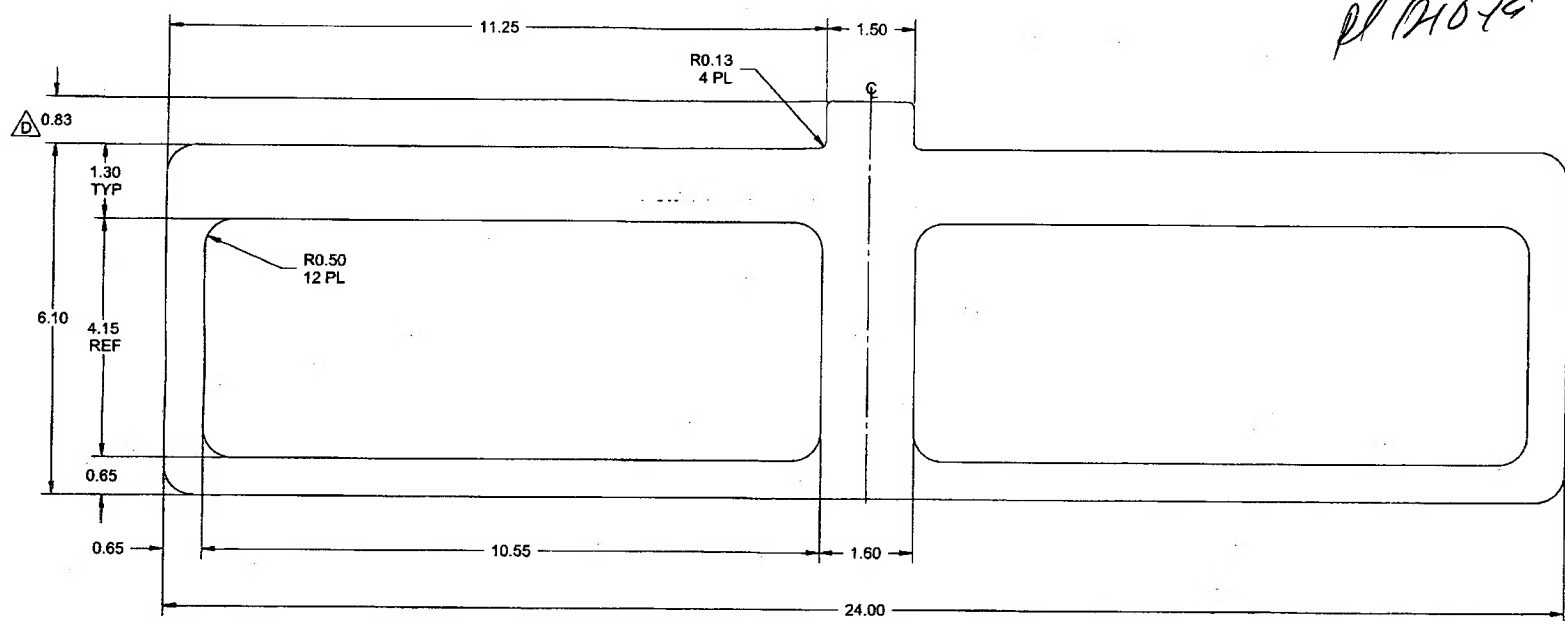
DRAWING NO. **D3256** REV. D
SHEET 1 OF 2

TITLE **ACCESS PANEL** SCALE
NTS

COPYRIGHT © 2004 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

91845
R/121049



D3256-3 GASKET

RELEASE
2011-11-10
UNDER REVIEW
12.10.10

- NOTES:
- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
REF. DART SPEC. MDURAS.035
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

DESIGN	#	DART AEROSPACE LTD	
DRAWN	#	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. D
MFG. APPR.	#	D3256	SHEET 2 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	ACCESS PANEL	INTS
DATE	11.10.25	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1